

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010943**Date Inspected:** 26-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai ,China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

(Blast Shop)

Segment 6AW

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the deck panel diaphragm to U-Rib welds. The Weld Designations are as follows:

DP084-001-062, 063 and 065.

DP111-001-081, 082 and 084.

DP111-002-081, 082 and 084.

DP138-001-101, 103, 106, 108, 111, 114, 119, 122, 124 and 127.

DP165-001-101, 103, 106, 108, 111, 114, 119, 122, 124 and 127.

DP192-001-101, 103, 106, 108, 111, 114, 119, 122, 124 and 127.

DP219-001-101, 103, 106, 108, 111, 114, 119, 122, 124 and 127.

DP246-001-101, 103, 106, 108, 111, 114, 119, 122, 124 and 127.

DP273-001-065, 068, 070, 073 and 076.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the floor beam component welds. The Weld Designations are as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SSD11-PP39-003 and 124.

SSD11A-PP39-1`38, 140, 144 and 148.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the corner assembly component welds. The Weld Designations are as follows:

CSD2-PP38.5-007~014, 017, 018, 027 and 028.

CSD9-PP39-001, 003, 007, 009 and 011.

SEG027M-018, 021 and 022.

During random verification Magnetic Particle Testing of the internal components of OBG segment 6AW, Caltrans Quality Assurance (QA) Inspector discovered a total of two (2) transverse cracks that measured from 5mm to 20mm in length. These welds were previously tested accepted by ZPMC (MT) technicians.

The affected weld designations are as follows;

Open Rib Stiffener to corner assembly web plate weld- CSD2-PP38.5-010 (1) 5mm Transverse Crack.

Longitudinal Girder to panel point 38 Weld –SEG027M-018 (1) 20mm Transverse Crack.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant conversations



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: Patterson,Rodney

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer